

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014534**Date Inspected:** 14-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng wei/ Zhou cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

FCAW welding of weld joint 3G-043 located on PCMK SEG3005F of Segment 12BW welder is identified as 045175. ZPMC QC is identified as Mr. Zhong yong gang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

SMAW welding of weld joint 3F-120 located on PCMK SEG3001L of Segment 12AE welder is identified as 066459. ZPMC QC is identified as Mr. Wang xu . The welding variables recorded by QC appeared to Comply with the WPS-B-T-4113-2.

FCAW welding of weld joint 3G-009 located on PCMK SEG3001R of Segment 12AE welder is identified as 201087. ZPMC QC is identified as Mr. Wang xu . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

SMAW repair welding of weld joint 2G-057 located on PCMK SEG3004X of Segment 12BW welder is identified as 047864. ZPMC QC is identified as Mr. Zhong yong gang. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-G(2F)-FCM-Repair and approved CWR1501.

During in process inspection in segment 12AE it is found that the Fit-up of Corner assembly to deck panel splice

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weld is identified as SEG3001\*-025, the clamp used for this joint fit-up temporary welds are welded over the deck panel U-rib partial joint penetration. This informed to ZPMC CWI  
Mr. Geng wei.

During in process inspection following location where the fillet weld is converted into complete joint penetration weld because of root gap is more than 5mm , prior to get approval from engineer we checked all the locations with ZPMC QC Mr. Zhong guo hui. The segment is 12AE and the welds are identified as  
SEG3001H-124/125, 118/119.  
SEG3001F-188/189.  
SEG3001D-101/102,105/106,109/110.  
SEG3001C-054/055.p  
SEG3001B-188/189,184/185,176/177.172/173.

### OUTSIDE SHOP

#### 10CE

SMAW welding of weld joint 4G-011 located on PCMK OBE10A of Segment 10CE welder is identified as 043661. ZPMC QC is identified as Mr.Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-FCM-1.

FCAW welding of weld joint 4G-164 located on PCMK FB020-005 of Segment 10CE welder is identified as 201087. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

#### BAY#16

Cutting and beveling of bottom plate for Lift 13AW is in progress, ZPMC QC Mr.Li ming yang present during this operation is appeared with Project specification.

#### BAY#19

FCAW welding of weld joint 2G-049 located on PCMK SB015-049 of Lift 8 welder is identified as 062761. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132-Tc-U4b-F.

FCAW welding of weld joint 2G-005 located on PCMK SB015-062 welder is identified as 062738. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

Ongoing heat straightening of FL-3 bottom plate is identified as BP3017-001 heating temperature, dimension checked with ZPMC QC Mr. Zhou cheng and recorded by QC appeared to comply with the HSR1(B)-8017.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

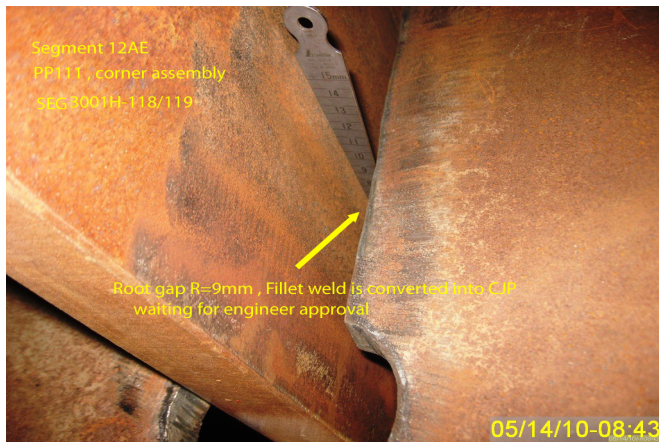
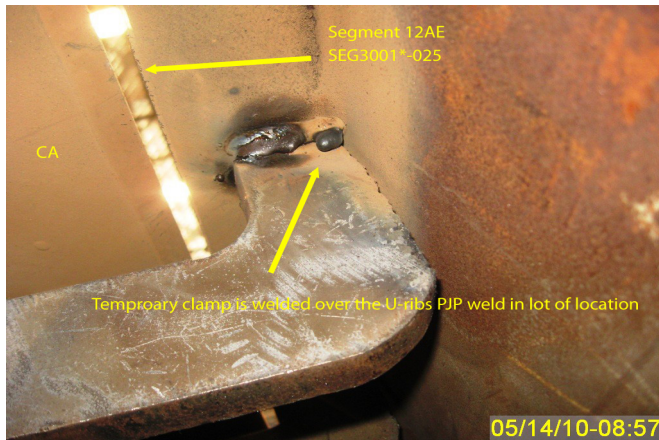
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documents.



## Summary of Conversations:

No relevant Conversation.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Chadra

Quality Assurance Inspector

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**Reviewed By:** McClendon,Timothy

QA Reviewer